Amendments to the Claims

Please amend claims 1-20. The pending claims are listed below.

Claim 1 (Currently Amended): A method for manufacturing a ~~glass or ceramic~~ disk substrate for a rotating disk drive data storage device, comprising the steps of:

providing a ~~ceramic or glass~~ disk substrate having a circumferential edge, said disk substrate being of a material from the set of materials consisting of: glass, ceramic, and a combination of glass and ceramic;

loading said disk substrate to an edge finishing apparatus; and

grinding said circumferential edge of said disk substrate in a ductile grinding regime using said edge finishing apparatus.

Claim 2 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 1, wherein said disk drive data storage device is a rotating magnetic disk drive data storage device, said disk substrate being subsequently coated with a magnetic coating after said grinding step.

Claim 3 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 1, further comprising the step of coarse grinding said circumferential edge in a non-ductile mode, said step of coarse grinding said circumferential edge in a non-ductile mode being performed before said step of grinding said circumferential edge in a ductile grinding regime.

Claim 4 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 1, wherein said disk substrate contains an outer circumferential edge at the periphery thereof and a central aperture defining an inner circumferential edge, and wherein said grinding step is applied to both said outer circumferential edge of said disk substrate and to said inner circumferential edge.

Claim 5 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 1, wherein said grinding step comprises grinding said edge with a formed grinding appliance conforming to an edge radius at said circumferential edge.

Claim 6 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 1, wherein said grinding step comprises bringing a grinding appliance of said edge finishing apparatus in contact with said circumferential edge and providing relative motion between said grinding appliance and circumferential edge of approximately 30 m/sec or more.

Claim 7 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 1, wherein said edge finishing apparatus comprises a grinding appliance having diamond particles of approximately 6 microns or less.

Claim 8 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 1, wherein said ~~glass or ceramic~~ disk substrate is finished for installation in a disk drive data storage device without chemical strengthening of said disk substrate.

Claim 9 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 8, wherein said ~~glass or ceramic~~ disk substrate is of a material which is not chemically strengthenable.

Claim 10 (Currently Amended): A method for manufacturing a ~~glass or ceramic~~ disk substrate for a rotating disk drive data storage device, comprising the steps of:

providing an ~~ceramic or glass~~ disk substrate having a cut, unfinished circumferential edge, said disk substrate being of a material from the set of materials consisting of glass, ceramic, and a combination of glass and ceramic, wherein said ~~ceramic or glass~~ disk substrate material is not chemically strengthenable; and

finishing said circumferential edge of said disk substrate to a finished state suitable for use in a disk drive data storage apparatus using at least one edge finishing apparatus.

Claim 11 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 10, wherein said step of finishing said circumferential edge of said disk substrate comprises grinding said edge in a ductile grinding regime.

Claim 12 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 10, wherein said disk drive data storage device is a rotating magnetic disk drive data storage device, said method further comprising the step of coating at least one flat surface of said disk substrate with a magnetic coating, said coating step being performed after said grinding step.

Claim 13 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 10, wherein said disk substrate contains an outer circumferential edge at the periphery thereof and a central aperture defining an inner circumferential edge, and wherein said finishing step comprises finishing both said outer circumferential edge of said disk substrate and said inner circumferential edge.

Claim 14 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 10, wherein said step of finishing said circumferential edge grinding step comprises forming an edge radius at said circumferential edge.

Claim 15 (Currently Amended): A method for manufacturing a ~~glass or ceramic~~ disk substrate for a rotating disk drive data storage device, comprising the steps of:

providing a ~~ceramic or glass~~ disk substrate having a cut, unfinished circumferential edge, said disk substrate being of a material from the set of materials consisting of glass, ceramic, and a combination of glass and ceramic;

finishing said circumferential edge of said disk substrate to a finished state suitable for use in a disk drive data storage apparatus by application of mechanical forces using at least one edge finishing apparatus, said finishing step being accomplished without chemical strengthening of said ~~glass~~ disk substrate.

Claim 16 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 15, wherein said disk substrate is of a material which is not chemically strengthenable.

Claim 17 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 15, wherein said step of finishing said circumferential edge of said disk substrate comprises grinding said edge in a ductile grinding regime.

Claim 18 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 15, wherein said disk drive data storage device is a rotating magnetic disk drive data storage device, said method further comprising the step of coating at least one flat surface of said disk substrate with a magnetic coating, said coating step being performed after said grinding step.

Claim 19 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 15, wherein said disk substrate contains an outer circumferential edge at the periphery thereof and a central aperture defining an inner circumferential edge, and wherein said finishing step comprises finishing both said outer circumferential edge of said disk substrate and said inner circumferential edge.

Claim 20 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate of claim 15, wherein said step of finishing said circumferential edge grinding step comprises forming an edge radius at said circumferential edge.

Claims 21-43 (Cancelled)